

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

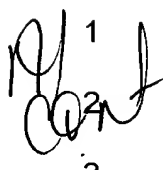
1 Claim 1 (presently amended): A method of making a clad self-brazing alloy
2 comprising the steps of providing a base metal alloy, providing a cladding consisting
3 essentially of copper and aluminum, and pressing said cladding to said base metal
4 alloy to bond said cladding to and form a brazing layer on said base metal alloy,
5 said base metal alloy having a melting point higher than said cladding, said cladding
6 having an initial thickness of at least 0.012 inches prior to being pressed to said
7 base metal alloy. *D. 306 mm*

AI 1 Claim 2 (presently amended): A method of making a clad self-brazing alloy
2 comprising the steps of providing a base metal alloy, providing a cladding consisting
3 essentially of copper and nickel, and pressing said cladding to said base metal alloy
4 to bond said cladding to and ~~from~~ form a brazing layer on said base metal alloy, said
5 base metal alloy having a melting point higher than said cladding, said cladding
6 being essentially free of zinc and comprising nickel in a proportion of 10% to 28%.

1 Claim 3 (original): A method of making a clad self-brazing alloy according to
2 claim 1 or 2, wherein said pressing comprises the step of roll bonding to form a roll
3 bonded composite.

1 Claim 4 (original): A method of making a clad self-brazing material according
2 to claim 3, wherein said cladding comprises layers of commercially pure copper and
3 commercially pure aluminum.

1 Claim 5 (original): A method of making a clad self-brazing material according
2 to claim 4, wherein the thickness of the copper and aluminum layers are selected to
3 produce a cladding consisting essentially of 2% aluminum to up to 100% aluminum.

 1 Claim 6 (original): A method of making a clad self-brazing material according
2 to claim 4, wherein the thickness of the copper and aluminum layers are selected to
3 produce a cladding consisting essentially of 2% aluminum to 30% aluminum.

1 Claim 7 (original): A method of making a clad self-brazing material according
2 to claim 4, wherein the thickness of the copper and aluminum layers are selected to
3 produce a cladding consisting essentially of 5% aluminum and the balance copper.

1 Claim 8 (original): A method of making a clad self-brazing material according
2 to claim 4, wherein the thickness of the copper and aluminum layers are 0.030" and
3 0.0075", respectively, prior to said roll bonding step.

1 Claim 9 (original): A method of making a clad self-brazing material according

2 to claim 4, wherein the thickness of the copper and aluminum layers are 0.030" and
3 0.012", respectively, prior to said roll bonding step.

1 Claim 10 (original): A method of making a clad self-brazing material
2 according to claim 4, wherein said base metal alloy is stainless steel.

1 Claim 11 (original): A method of making clad self-brazing material according
2 to claim 4, including the further step of cold rolling said roll bonded composite to a
3 final gauge.

1 Claim 12 (original): A method of making a clad self-brazing material
2 according to claim 11, wherein said final gauge is 0.017".

1 Claim 13 (original): A method of making a clad self-brazing material
2 according to claim 4, wherein said layers are on each side of said base metal alloy.

1 Claim 14 (original): A method of making a clad self-brazing material
2 according to claim 13, wherein copper comprises an outer layer on each side of said
3 composite.

1 Claim 15 (original): A method of making a clad self-brazing material
2 according to claim 4, wherein copper comprises an outer layer of said composite.

1 Claim 16 (original): A method of making a clad self-brazing material
2 according to claim 15, wherein said base metal comprises another outer layer of
3 said composite.

1 Claim 17 (original): A method of making a clad self-brazing material
2 according to claim 16, wherein said base metal is stainless steel.

AI Conf 1 Claim 18 (original): A method of making a clad self-brazing material
2 according to claim 3, wherein said cladding comprises layers of commercially pure
3 copper and commercially pure nickel.

1 Claim 19 (presently amended): A method of making a clad self-brazing
2 material according to claim 18, wherein the ~~thickness~~ thicknesses of the copper and
3 nickel layers are selected to produce a cladding consisting essentially of 10% to up
4 to ~~100%~~ 25% nickel.

1 Claim 20 (presently amended): A method of making a clad self-brazing alloy
2 according to claim 18, wherein the ~~thickness~~ thicknesses of the copper and nickel
3 layers are selected to produce a cladding consisting essentially of 20% to ~~40%~~ 28%
4 nickel.

1 Claim 23 (presently amended): A clad self-brazing alloy comprising a base
2 metal alloy sheet having a cladding consisting essentially of layers of commercially
3 pure copper and aluminum metallurgically bonded to each other and to said base
4 metal to form a composite, said aluminum layer having an initial thickness of at least
5 0.012 inches prior to being metallurgically bonded to said copper layer.

1 Claim 24 (presently amended): A clad self-brazing alloy according to claim
2 23, wherein said cladding ~~aluminum~~ comprises 2% up to 100% of said ~~cladding~~
3 aluminum.

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1 Claim 25 (presently amended): A clad self-brazing alloy according to claim
2 23, wherein said ~~aluminum~~ cladding comprises 2% to 30% of said
3 ~~cladding~~ aluminum.

1 Claim 26 (presently amended): A clad self-brazing alloy according to claim
2 23, wherein said ~~aluminum~~ cladding comprises 5% of said ~~cladding~~ aluminum.

1 Claim 30 (presently amended): A clad self-brazing alloy according to claim
2 23, wherein said layers of copper and aluminum ~~and~~ are metallurgically bonded to
3 each face of said base metal sheet.

1 Claim 31 (presently amended): A clad self-brazing alloy according to claim
2 30, wherein ~~copper comprises~~ an outer layer on each face of said composite
3 comprises copper.

1 Claim 32 (presently amended): A clad self-brazing alloy according to claim
2 23, wherein ~~copper comprises~~ an outer layer of said composite comprises copper.

1 Claim 33 (presently amended): A clad self-brazing alloy according to claim
2 32, wherein ~~said base metal comprises another~~ an outer layer of said composite
3 comprises said base metal.

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1 Claim 35 (presently amended): A clad self-brazing alloy comprising a base
2 metal alloy sheet having a cladding consisting essentially of layers of commercially
3 pure copper and nickel metallurgically bonded to each other and to said base metal
4 to form a composite said cladding comprising 10% to 28% nickel.

1 Claim 36 (presently amended): A clad self-brazing alloy according to claim
2 35, wherein said ~~nickel cladding~~ comprises 10% to ~~up to 100%~~ 25% nickel.

1 Claim 37 (presently amended): A clad self-brazing alloy according to claim
2 35, wherein said ~~nickel cladding~~ comprises 20% to ~~40%~~ 28% ~~of said cladding~~ nickel.

1 Claim 38 (presently amended): A clad self-brazing alloy according to claim
2 35, wherein said ~~nickel-cladding~~ comprises 25% of said ~~cladding~~ nickel.

1 Claim 39 (original): A clad self-brazing alloy according to claim 35, wherein
2 the thickness of the copper and nickel layers are 0.03" and 0.010", respectively.

1 Claim 40 (original): A clad self-brazing alloy according to claim 35, wherein
2 said base metal alloy is stainless steel.

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1 Claim 41 (presently amended): A clad self-brazing alloy according to claim
2 35, wherein ~~copper comprises~~ an outer layer of said composite comprises copper.

1 Claim 42 (new): A method according to claim 1, said cladding being made by
2 roll bonding discrete layers of copper and aluminum, at least one of which layers
3 has an initial thicknesses of at least 0.012 inches prior to roll bonding.

1 Claim 43 (new): A method according to claim 1 or 2, further comprising the
2 step of brazing said self-brazing alloy to a metal surface at elevated temperature.

1 Claim 44 (new): A method according to claim 43, said elevated temperature
2 being at least 1130°C.

1 Claim 45 (new): A method according to claim 43, said elevated temperature
2 being 1130°C.

1 Claim 46 (new): A method according to claim 43, said elevated temperature
2 being at least 1200°C.

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1 Claim 47 (new): A method according to claim 43, said elevated temperature
2 being 1200°C.

1 Claim 48 (new): A clad self-brazing alloy according to claim 35, said cladding
2 being essentially free of zinc.
